

Date: Monday, 23/02/2009 10:11:43 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BASKET BASE ASSEMBLY (350)		
Job Number	: 45949C			Part Number	: D2221		
Estimate Number	: 10189			Drawing Number	: D2221 REV H		
P.O. Number	:			Project Number	: N/A		
This Issue	: 23/02/2009 S.O. No. :			Drawing Revision	: H		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : LARGE FAB ASSY			Due Date	: 03/03/2009 Qty: 1 Um: Each		
Previous Run	: 45948A						
Written By	:						
Checked & Approved By	: <u>JUL 09.02.23</u>						
Comment	: Est Rev:J 05.09.02 Added D3442-1 KJ/JLM						
	Est Rev:K 08-08-29 revG as per dwg DD verified by:EC						
	Est Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC						
	Est Rev:M 08-12-02 revH as per dwg DD verified by:						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D22211	Rib	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	Rib	
	batch: <u>B44864</u>		<u>PD 09.03.02</u>
2.0	D22215	Rib	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	Rib	
	batch: <u>B45807</u>		<u>PD 09.03.02</u>
3.0	D22217	Rib	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	Rib	
	batch: <u>B45781</u>		<u>PD 09.03.02</u>
4.0	D22323	Basket Hinge	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	Basket Hinge	
	batch: <u>B42075</u>		<u>PD 09.03.02</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D22351

Basket Rib



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Rib

batch: B43985

PD

09-03-02

6.0 D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

batch: B43800

PD

09-03-02

7.0 D34421

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Shim

batch: B45226

PD

09-03-02

8.0 D3825041

Rib Assembly (Basket End)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rib Assembly (Basket End)

batch: B45942

PD

09-03-02

9.0 D3826041

Rib / Gusset Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rib / Gusset Assembly

batch: B45943

PD

09-03-02

10.0 D3827041

Rib Assembly (Inboard)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib Assembly (Inboard)

batch: B45809

PD

09-03-02

11.0 D38331

Mesh (Base End Face)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mesh (Base End Face)

batch: B45896

PD

09-03-03

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 45949C

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 D38321

Mesh (Base)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mesh (Base)

batch: B456W

PD

09-03-03

13.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221

2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221

3- tack weld mesh on basket as per dwg D2221

A/R ER316 S.S. Rod Batch: M107051

PD

09-03-03

14.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-03-04

15.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

SD 09-03-04 (X)

16.0 POWDER COATING

POWDER COATING



M110939

Comment: POWDER COATING

1- Plug holes prior to powder coating

2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

1:25

START TIME:

400°

OVEN TEMPERATURE:

1:55

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

FL 09/03/04 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #: Machine Or Operation:

Description :

17.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



10503-090

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

18.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF

09-03-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

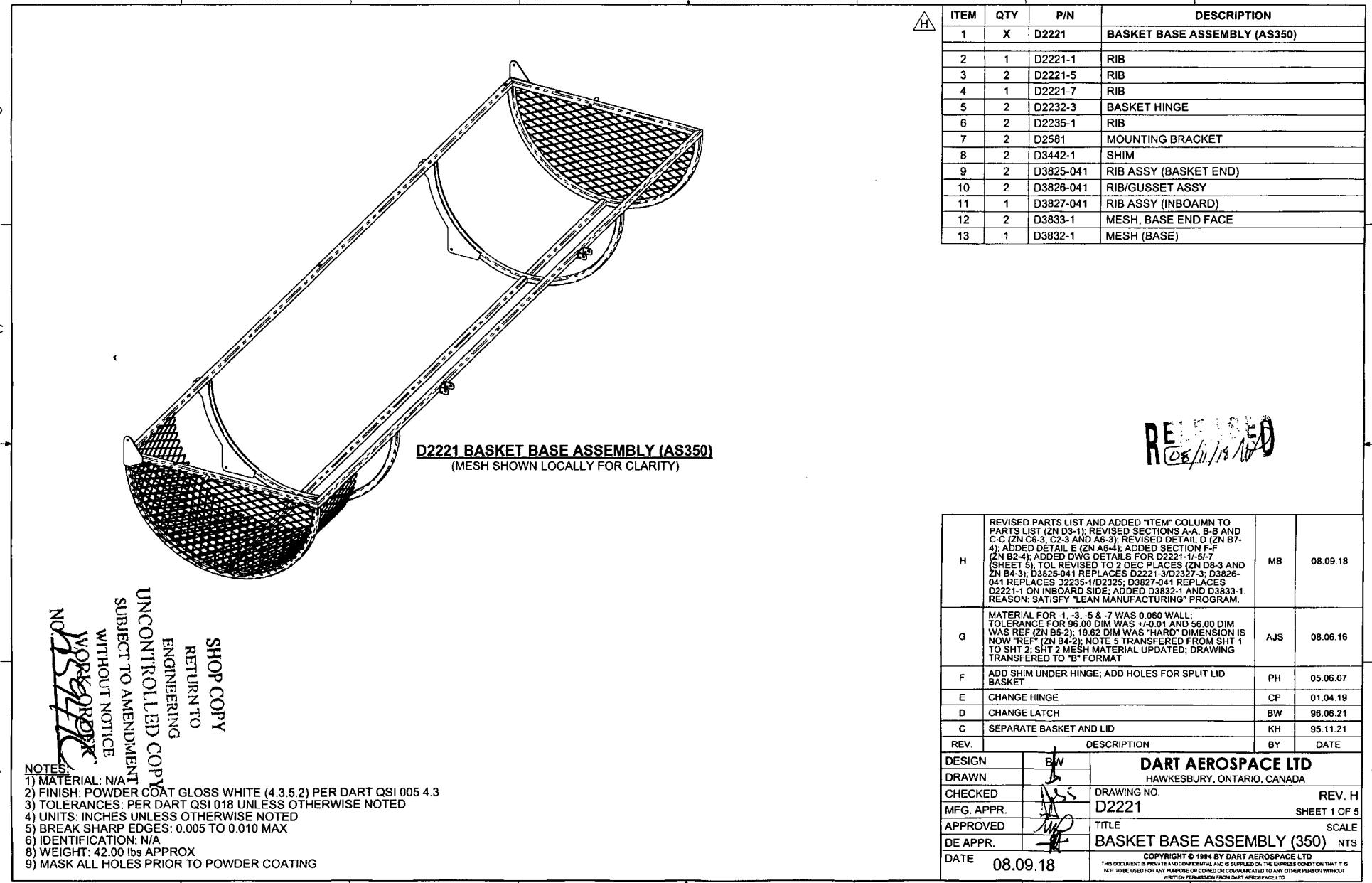
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

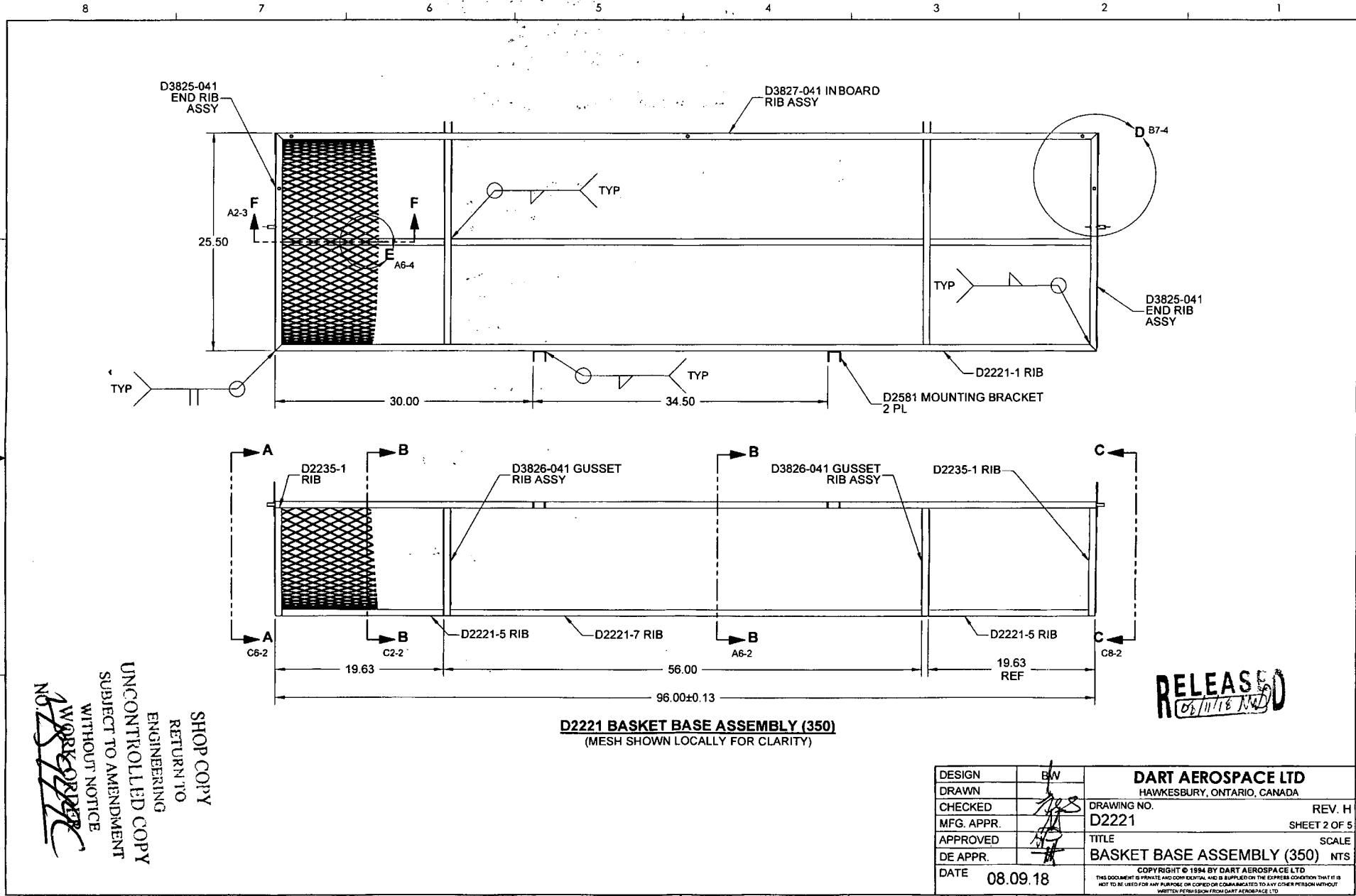
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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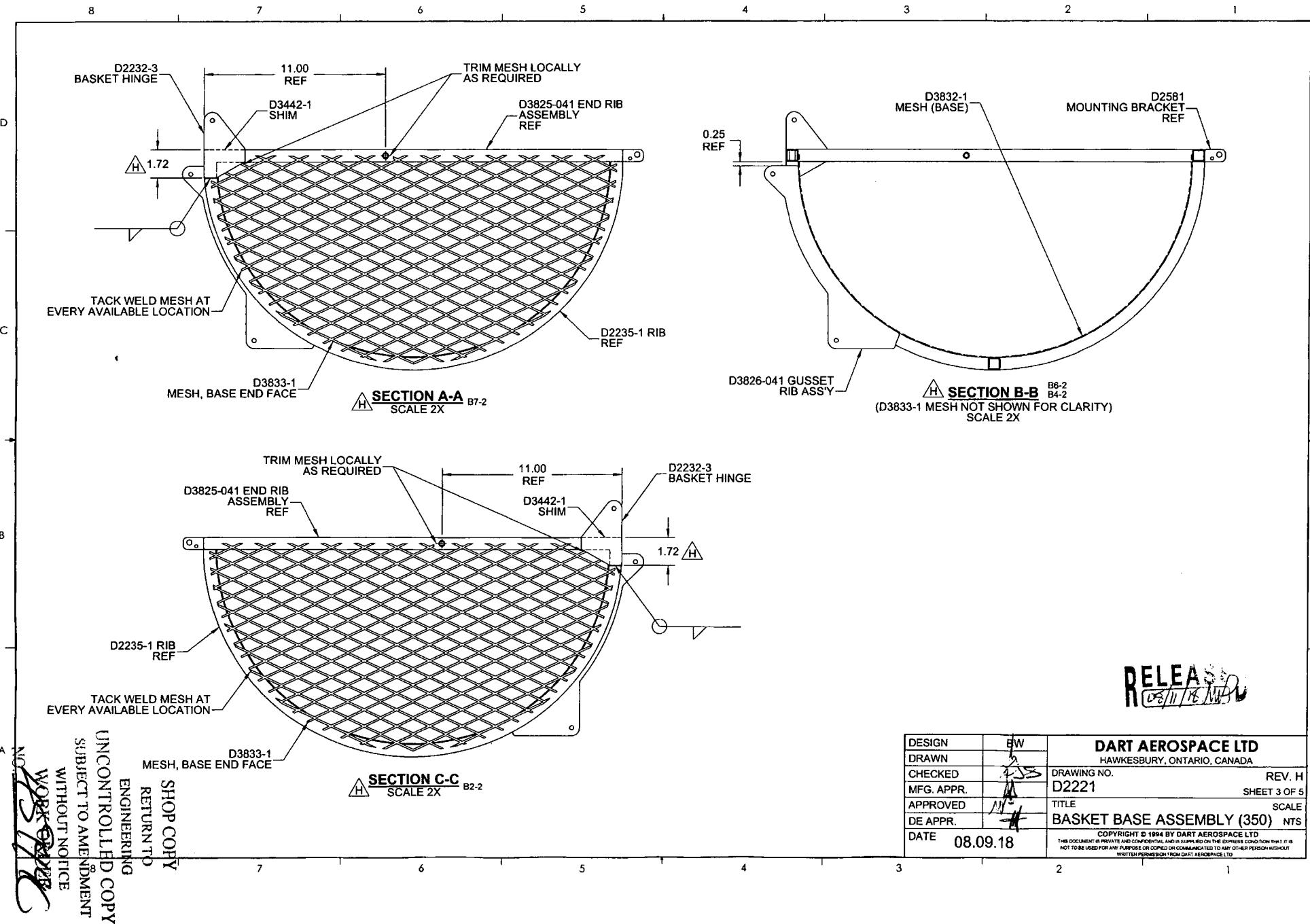
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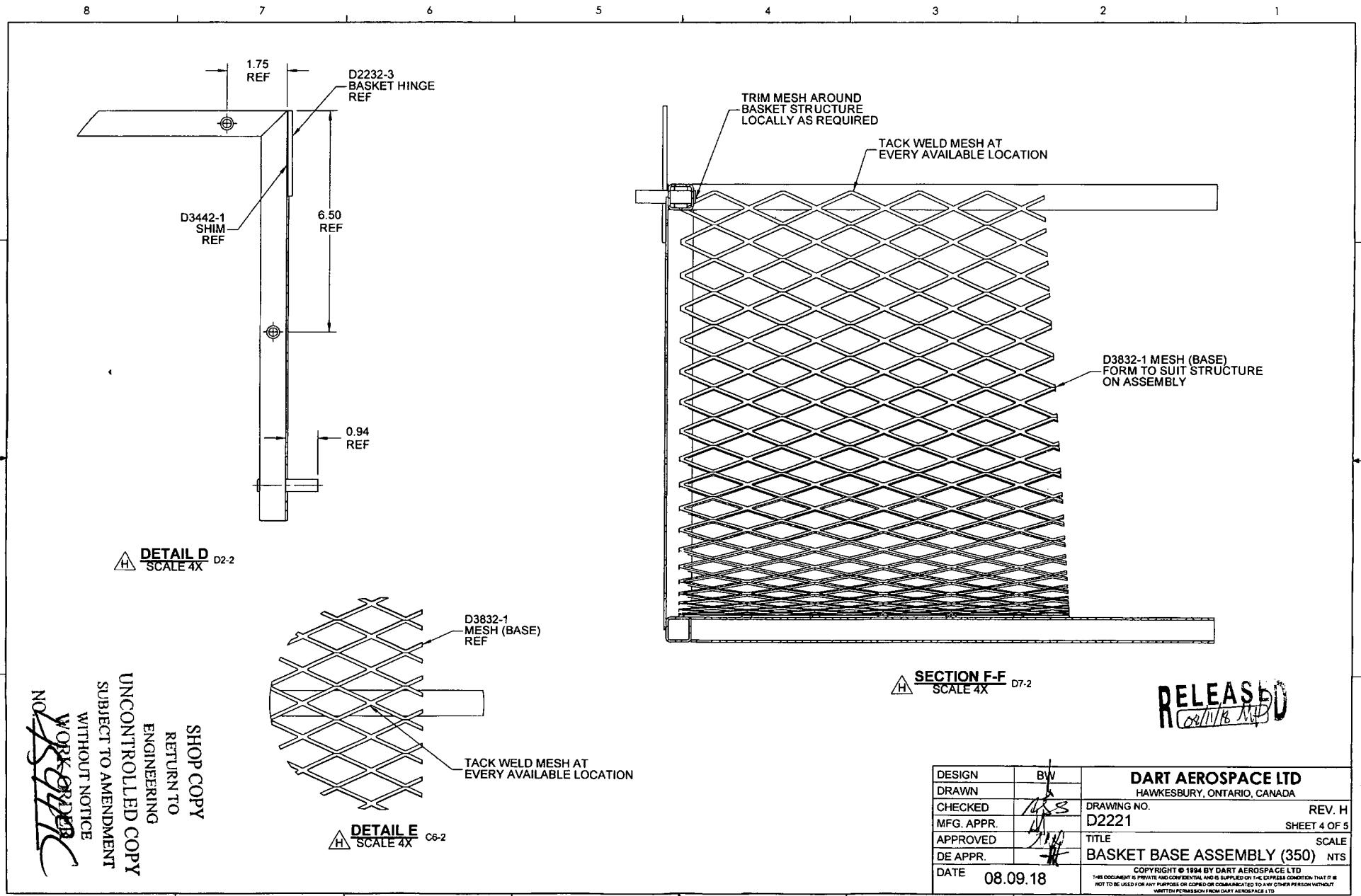


8 7 6 5 4 3 2 1



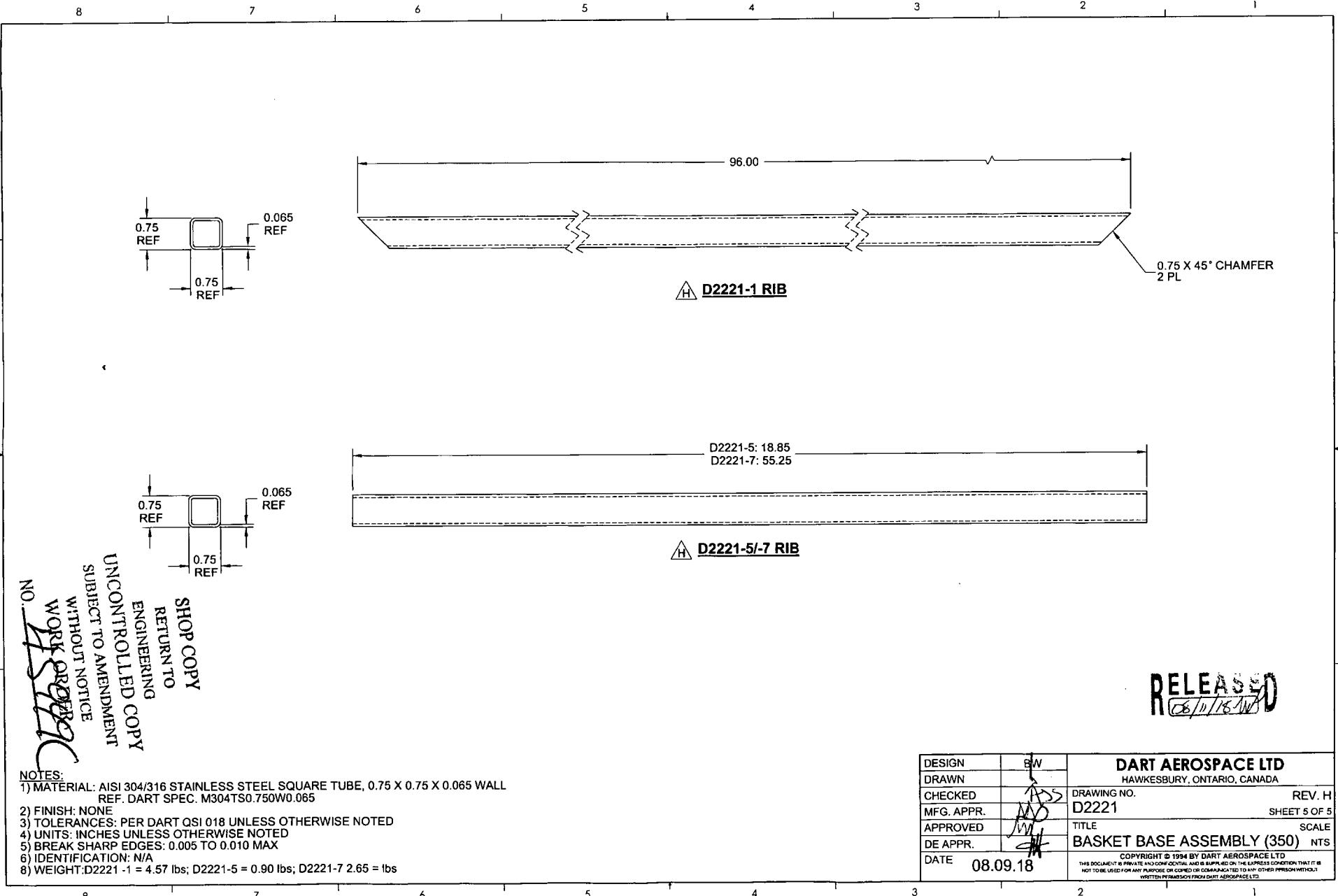
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APPROVED		SHEET 2 OF 5	
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APPROVED	AS	SHEET 4 OF 5	
DE APPR.	AS	TITLE	
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APPROVED	✓	SHEET 5 OF 5	
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